

40

W/O Split

DART AEROSPACE LTD	Work Order:	21383 A
Description: Bracket	Part Number:	D3145-1
Dwg: D3145 Rev. B	Qty:	109 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.08.23	10
2	MV	Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2.000x2.000 Batch: M16351	SD	05/01/14	10
3	MV	Machine per Folio FA318 and Dwg D3145	E/S	05.01.26	9
4	QC2	Inspect parts as they come off the CNC machine	E/S	05.01.26	9
5	MV	Deburr and Tumble	E/S	05.02.02	9
6	QC5	Second inspection	ML	05.02.02	9
7	FP	Chemical Conversion Coat per QSI 005 4.1	ML	05.02.09	9
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	ML	05.02.09	9
9	QC3	Inspect work to Step 8	CL	05/02/09	9
10	ST	Identify and Stock	CL	05/02/09	9
11	AC	Cost / part 108.54	SAC	05-02-11	9
12	DC	Close W/O 114.85 Inspect Level 21	KJ	05.02.10	9

Rev	Date	Change	Revised By	Approved
A	03.02.28	New issue	KJ/RF	RF

RELEASED
03.03.04 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 21383A		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05.02.02	3	- 2 parts scrap, due to wrong cutter. (HSS instead of carbide)	B	destroy	B 05.02.02	B 05.02.09	BB proven	BB 05.02.09
05.02.02	3	- 1 part is not under by 0.010", see attached Dwg. for specified affected area.	B	destroy	B 05.02.08	B 05.02.09	BB proven	BB 05.02.09

PAR#: N/A

Fault Category: Manuf/knc cell

DQA:

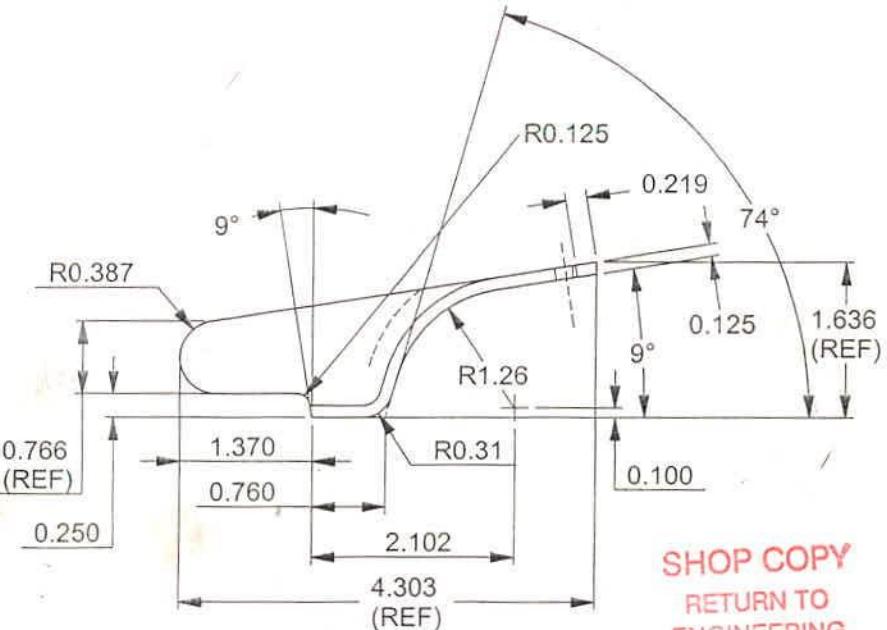
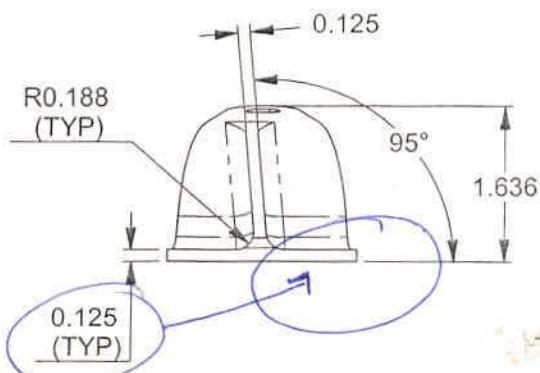
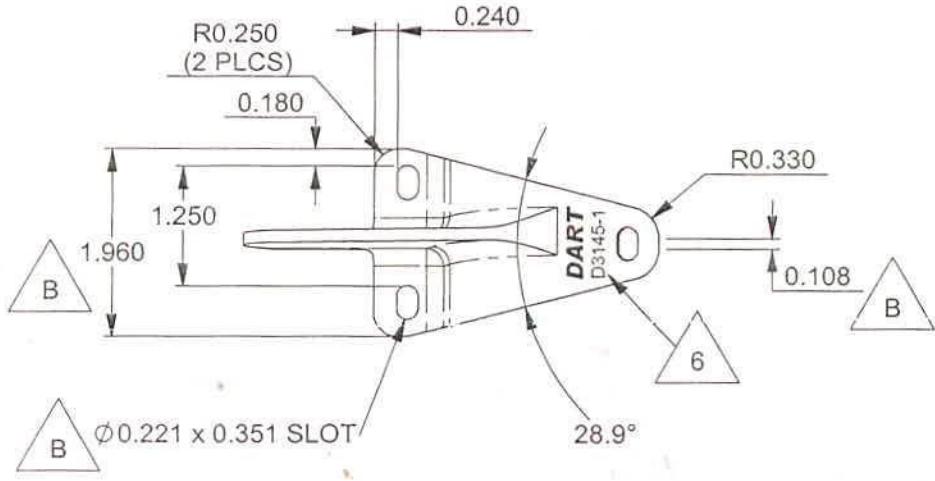
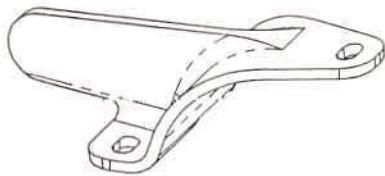
Date: 05/02/10

DART

DESIGN <i>RF</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HF</i>	APPROVED <i>HF</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2

RELEASED
03.03.18 *HF*

A	02.04.24	NEW ISSUE
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

WORK ORDER
NO. 21383

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
HawkesburyAug 23, 2004
09:51 am

Work Order No : 0021383 A
 Project Name : D3145-1
 Project For : WK440
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3145-1
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 109
 Amount Done : 0
 Start Date : 08-23-04
 Est Finish Date : 09-21-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD	Work Order:	21383
Description: BRACKET	Part Number:	D3145-1
Inspection Dwg: D3145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	$\pm .010$	0.243	✓		Vernier	
0.180	$\pm .010$	0.184	✓		Vernier	
R0.250	$\pm .010$	R0.250	✓		vernier R-6	
1.250	$\pm .010$	1.249	✓		Vernier	
1.960	$\pm .016$	1.965	✓		Vernier	
$\times 0.221 \times 3.51$	$\pm .016$	$\times 0.221 \times 3.44$	✓		Vernier	
0.108	$\pm .010$	0.108	✓		Vernier	
0.125	$\pm .016$	0.125	—		Vernier	
1.636	$\pm .016$	1.640	—		Vernier	
R0.188	$\pm .016$	R0.188	✓		Vernier	
0.125	$\pm .010$	0.120	✓	reject	Vernier	
95°	$\pm .12$	95°	—		Protractor	
R0.387	$\pm .016$	R0.390	—		R-6	
0.766	$\pm .016$	0.766	—		Vernier	
0.250	$\pm .010$	0.248	✓		Vernier	
1.370	$\pm .016$	1.375	✓		Vernier	
0.760	$\pm .016$	0.760	—		Vernier	
4.303	$\pm .016$	4.304	✓		Vernier	
0.219	$\pm .016$	0.219	✓		Vernier	

Measured By:	<i>mh</i>	Audited by:	<i>PC</i>	Prototype Approval:	<i>N/A</i>
Date:	05/01/31	Date:	05.02.02	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	